

Date: Monday, 1/8/2007 11:08:48 AM  
User: Kim Johnston

## Process Sheet

SPLIT - 2

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 30200  
Estimate Number : 11060  
P.O. Number : N/A  
This Issue : 1/8/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 29705  
Drawing Name : SUPPORT (412 AFT)  
Part Number : D28961  
Drawing Number : D2896 REV A4 B AP 01/01/10  
Project Number : N/A  
Drawing Revision : A4 B AP 01/01/10  
Material : N/A  
Due Date : 1/30/2007 Qty: 20 Um: Each  
Written By :  
Checked & Approved By : 02.01.08  
Comment : Est: B 02.11.26 Reformat; Added P/O; Added mask hole KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2830

Description: D6104-011

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2896-1

2.0 D6104011 17-4 SS Roundbar 6.50"OD

Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
Support

Batch 30200

15 deducted MS 01/01/25

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn blank for Haas as per Folio FA167

2F

07/03/05

BC / MS

01/01/25

5.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BC / MS

01/01/25

07.03.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/28	6	Ø.625" hole is not within .003 perpendicular to the 1.764" bore. The bore is off .006. - 6 parts	07/06/26	<del>to replace</del> All scrap is recorded on the original W/O ① Test fit on a set-up	<del>J.F.</del> Add AUG 08	✓ AUG 08	07/06/26	0703.28

NOTE: Date & initial all entries



Date: Monday, 1/8/2007 11:08:49 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT (412 AFT)

Job Number: 30200

Part Number: D28961

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: BAND SAW — → HAAS  
Machine as per Folio FA167  
Tumble & Deburr

J.F./J.L 07/03/28

7.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F./J.L 07/03/28

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mx 07/06/25 (2)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Mask Ø0.625" hole prior to paint

~~2T~~ 07-06-31

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Prime inside of supports  
2T 07-06-31

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

QC14



2T 07/09 4 supports



Comment: INSPECT POWDER COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: crate assy

2T 07/07/10 (2)

4 parts

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2T 07-07-16

Job Completion



u 07/07/11

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30200
<b>Description:</b> Support		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896 Rev. A4		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev A4/DSK080 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
<b>Lathe Section</b>									
A	3.480	3.485		3.485	3.485	3.485	3.485	3.485	
B	3.990	4.010		4.001	3.995	3.995	3.995		
C	3.825	3.845		3.834	3.837	3.837	3.837		
D	0.718	0.738		.727	.727	.727	.727		
E	0.090	0.110		.102	.102	.102	.102		
F	3.705	3.725		3.716	3.717	3.717	3.717		
G	1.360	1.380		1.364	1.364	1.364	1.364		
H	1.250	1.260		1.259	1.256	1.256	1.256		
I	6.490	6.510		6.495	6.495	6.495	6.495		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.107	0.127		.115	.115	.115	.115		
M									
<b>HAAS Section</b>									
AA	2.152	2.172							
AB	2.340	2.360							
AC	3.550	3.560							
AD	3.770	3.790							
AE	0.065 x 0.315	0.085 x 0.335							
AF	1.42	1.48							
AG	0.833	0.853							
AH	0.240	0.260							
AI	0.261	0.266	DT8707						
AJ	0.189	0.194	DT8706						
AK	1.990	2.010							
AL	0.625	0.630	DT8709						
AM	101.75	105.75	DT8697						
AN	0.053	0.073							
AO	0.927	0.947							
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.003"</b>									
<b>Accept/Reject</b>									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	BE



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30200
<b>Description:</b> Support		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896 Rev. A4		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev A4/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
				5	6	7	8		
<b>Lathe Section</b>									
A	3.480	3.485		3.485	3.485	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.995	3.995		
C	3.825	3.845		3.833	3.833	3.833	3.833		
D	0.718	0.738		0.727	0.727	0.727	0.727		
E	0.090	0.110		0.103	0.103	0.103	0.103		
F	3.705	3.725		3.717	3.717	3.717	3.717		
G	1.360	1.380		1.370	1.370	1.370	1.370		
H	1.250	1.260		1.256	1.256	1.256	1.256		
I	6.490	6.510		6.495	6.495	6.495	6.495		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.240	0.260		0.250	0.250	0.250	0.250		
L	0.107	0.127		0.117	0.117	0.117	0.117		
M									
<b>HAAS Section</b>									
AA	2.152	2.172							
AB	2.340	2.360							
AC	3.550	3.560							
AD	3.770	3.790							
AE	0.065 x 0.315	0.085 x 0.335							
AF	1.42	1.48							
AG	0.833	0.853							
AH	0.240	0.260							
AI	0.261	0.266	DT8707						
AJ	0.189	0.194	DT8706						
AK	1.990	2.010							
AL	0.625	0.630	DT8709						
AM	101.75	105.75	DT8697						
AN	0.053	0.073							
AO	0.927	0.947							
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.003"</b>									
<b>Accept/Reject</b>									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30200
<b>Description:</b> Support		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896 Rev. A4		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev A4/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
<b>Lathe Section</b>									
A	3.480	3.485		3.485	3.485	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.995	3.995		
C	3.825	3.845		3.834	3.834	3.834	3.834		
D	0.718	0.738		0.727	0.727	0.727	0.727		
E	0.090	0.110		0.102	0.103	0.103	0.103		
F	3.705	3.725		3.717	3.717	3.717	3.715		
G	1.360	1.380		1.370	1.370	1.370	1.370		
H	1.250	1.260		1.256	1.256	1.256	1.256		
I	6.490	6.510		6.495	6.495	6.495	6.495		
J	0.022	0.042		0.030	0.032	0.032	0.032		
K	0.240	0.260		0.250	0.250	0.250	0.250		
L	0.107	0.127		0.115	0.115	0.115	0.115		
M									
<b>HAAS Section</b>									
AA	2.152	2.172							
AB	2.340	2.360							
AC	3.550	3.560							
AD	3.770	3.790							
AE	0.065 x 0.315	0.085 x 0.335							
AF	1.42	1.48							
AG	0.833	0.853							
AH	0.240	0.260							
AI	0.261	0.266	DT8707						
AJ	0.189	0.194	DT8706						
AK	1.990	2.010							
AL	0.625	0.630	DT8709						
AM	101.75	105.75	DT8697						
AN	0.053	0.073							
AO	0.927	0.947							
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.003"</b>									
<b>Accept/Reject</b>									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30200
<b>Description:</b> Support	<b>Part Number:</b> D2896-1
<b>Inspection Dwg:</b> D2896 Rev. A4	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev A4/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	2 14	3 15	4 16		
<b>Lathe Section</b>									
A	3.480	3.485		3.485	3.485	3.485	3.485	MB	07/03/05
B	3.990	4.010		3.995	3.995	3.995	3.995		
C	3.825	3.845		3.834	3.834	3.834	3.835		
D	0.718	0.738		.727	.725	.727	.730		
E	0.090	0.110		.102	.103	.103	.105		
F	3.705	3.725		3.717	3.717	3.717	3.715		
G	1.360	1.380		1.370	1.370	1.370	1.376		
H	1.250	1.260		1.256	1.256	1.256	1.257		
I	6.490	6.510		6.495	6.495	6.495	6.500		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.107	0.127		.115	.115	.115	.115		
M									
<b>HAAS Section</b>									
AA	2.152	2.172					2.172		
AB	2.340	2.360					2.353		
AC	3.550	3.560					3.550		
AD	3.770	3.790					3.775		
AE	0.065 x 0.315	0.085 x 0.335					.335x.065		
AF	1.42	1.48					1.450		
AG	0.833	0.853					.843		
AH	0.240	0.260					.250		
AI	0.261	0.266	DT8707				.263		
AJ	0.189	0.194	DT8706				.191		
AK	1.990	2.010					1.995		
AL	0.625	0.630	DT8709				.628		
AM	101.75	105.75	DT8697				/		
AN	0.053	0.073					.063		
AO	0.927	0.947					.947		
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.003"</b>									
<b>Accept/Reject</b>									

Measured by: J. B. / J. L.	Audited by: J. B.
Date: 07/03/05 / 07/03/27	Date: 07/06/25

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	BE



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30200
<b>Description:</b> Support		<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896 Rev. A4		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev A4/DSK080 Rev A and record below:

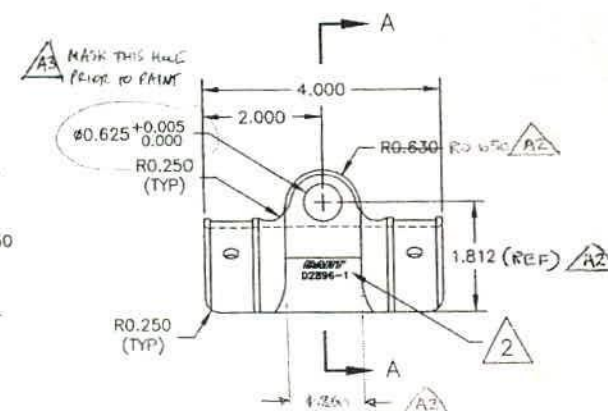
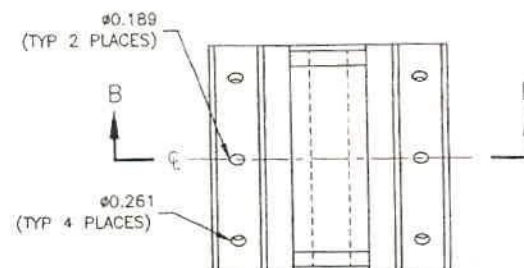
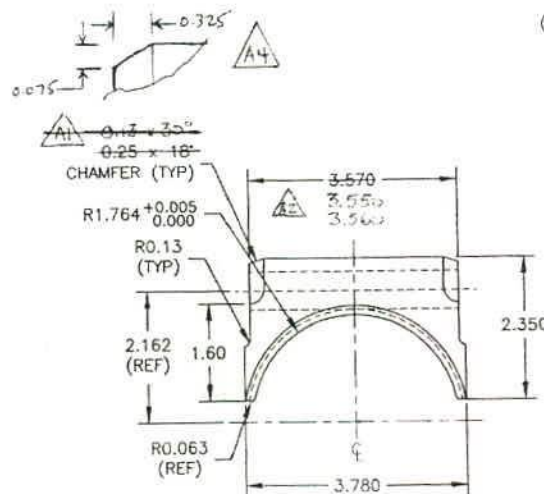
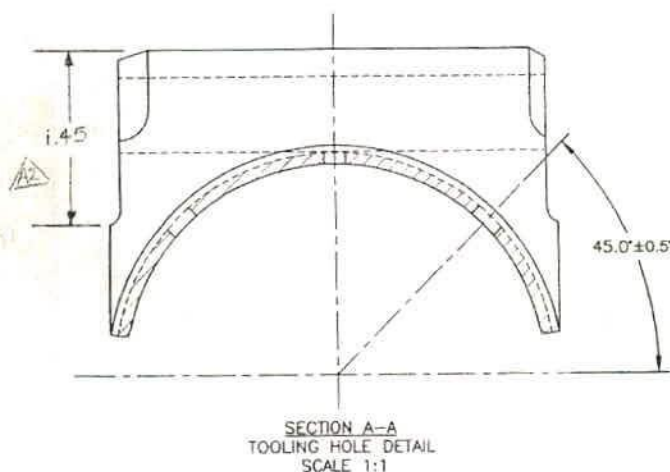
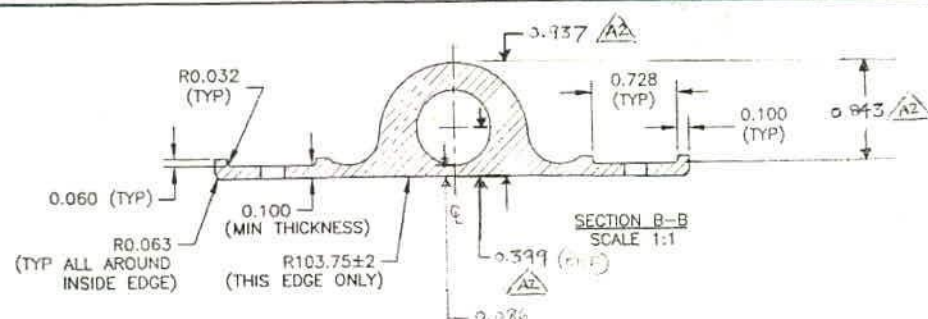
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
<b>Lathe Section</b>									
A	3.480	3.485		3.485	3.485	3.485	3.485	JF	07/03/05
B	3.990	4.010		3.995	3.995	3.995	3.995	BC	07/03/06
C	3.825	3.845		3.832	3.833	3.833	3.833		
D	0.718	0.738		.722	.722	.722	.722		
E	0.090	0.110		.105	.105	.105	.101		
F	3.705	3.725		3.719	3.719	3.717	3.715		
G	1.360	1.380		1.370	1.370	1.370	1.370		
H	1.250	1.260		1.257	1.257	1.257	1.257		
I	6.490	6.510		6.495	6.495	6.495	6.495		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.107	0.127		.115	.115	.115	.115		
M									
<b>HAAS Section</b>									
AA	2.152	2.172	→	2.172	2.172	2.172	2.172		
AB	2.340	2.360		2.359	2.354	2.349	2.353		
AC	3.550	3.560		3.556	3.552	3.550	3.553		
AD	3.770	3.790		3.770	3.772	3.772	3.771		
AE	0.065 x 0.315	0.085 x 0.335		.335x.065	.335x.065	.335x.065	.335x.065		
AF	1.42	1.48		1.450	1.454	1.450	1.450		
AG	0.833	0.853		.847	.849	.842	.845		
AH	0.240	0.260		.250	.250	.250	.250		
AI	0.261	0.266	DT8707	.262	.263	.263	.263		
AJ	0.189	0.194	DT8706	.189	.191	.191	.191		
AK	1.990	2.010	→	1.995	1.998	1.997	2.002		
AL	0.625	0.630	DT8709	.627	.628	.628	.628		
AM	101.75	105.75	→	103.75	✓	✓	✓		
AN	0.053	0.073		.063	.063	.063	.063		
AO	0.927	0.947	→	.944	.947	.947	.947		
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.003"</b>									
<b>Accept/Reject</b>									

Measured by: J.F. J.F./J.L.	Audited by: JML
Date: 07/03/05	Date: 07/06/05

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	BE



RELEASED  
01-11-13



D2896-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA  
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

D2896-1

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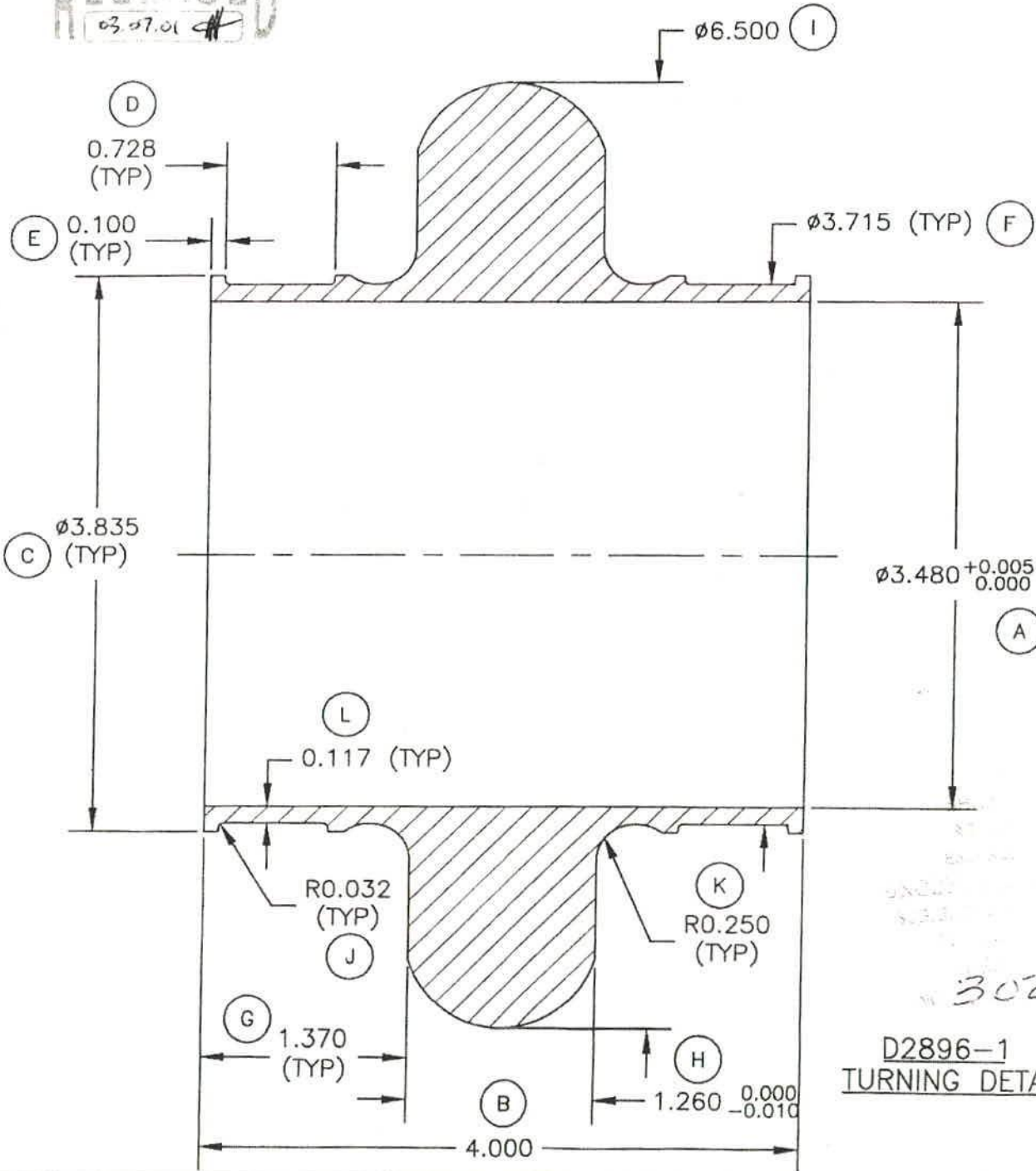
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DART AEROSPACE LTD.

A4	CP	04.05.14	CORRECT CHAMFER	DART AEROSPACE LTD. WARRICKSBURY, OXFORD, CANADA
A3	CP	02.11.20	ADD MASKING NOTE	
A2	CP	02.06.04	ADD DIMS, CHANGE RAD	
A1		01.11.13	CHANGED CHAMFER	
A		01.10.19	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP	
CHECKED	CP	APPROVED	CP	
DATE	01.10.19	TITLE	SUPPORT	
		DRAWING NO.	D2896	REV. A
				SHEET 1 OF 1
				SCALE
				1:2

**DART**

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01 [Signature]



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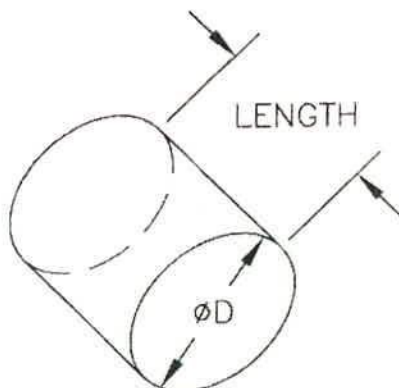




DESIGN 24	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4	SCALE NTS
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	



## SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRC)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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**VALBRUNA**

**SLATER STAINLESS, INC.**  
 2400 Taylor Street West, P.O. Box 630  
 Fort Wayne, Indiana USA 46801  
 Phone: 260-434-2892 Fax: 260-434-2805

**Product Certification Report****Report Number: 4245260**

Certified on Dec 19, 2006 Page 1 of 1

Order I.D. <b>0601898 001</b>		Order Date <b>6/15/06</b>		Commodity Code <b>15003</b>	
Dim 1 <b>6.5000</b>	Dim 2 <b>.0000</b>	Dim 3 <b>.0000</b>	Heat I.D. <b>243015</b>	Customer I.D. <b>001123</b>	Customer Purchase Order <b>01-19532</b>
Product Shape <b>Rounds</b>			Product Surface <b>HR &amp; Rough Turned</b>		Customer Grade <b>17-4</b>
Length (Inches) <b>120.000 Min. 168.000 Max.</b>			Bill of Lading # <b>404559</b>	Weight	

**Ship To**

**CASTLE METALS**  
**3400 NORTH WOLF ROAD**  
**FRANKLIN PARK, IL 60131**

**Sold To**

**VALBRUNA STAINLESS, INC.**  
**2400 TAYLOR STREET WEST**  
**FORT WAYNE, IN 46802**

**Lifts: 0064 0069****AISI 630****UNS S17400****AMS 2303E****CONDITION A****ASTMA 564-04****AMS 5643Q**

**3174-02 REV 23 DTD 11/15/01**  
**ASMESA 564 01 ED 2002 ADD**

**CHEMICAL ANALYSIS**

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	N	Cb	Ta	Cb+Ta
.040	.54	.023	.020	.36	15.58	4.67	.24	3.40	.03	.31	.001	.31
HB												
344												

**TENSILE PROPERTIES CAPABILITY**

HB	TS (PSI)	.2%YS (PSI)	%EL(2")	%RA	AGE(F)
417	198900	188000	14.0	49.8	900

**MAGNETIC PARTICLE TEST -****FREQ SEV****AVG .00 .00****MACRO ASTM E340/E381****MACRO****OK****OK****OK****CASTLE METALS FP****DATE REC'D 12.20.06 IAC/5003****APPROVED BY: SW****PERCENT FERRITE****% FERRITE****AVG .5****Reduction ratio 5 To 1 Min.****Electric Furnace melted; AOD refined.****Ultrasonic test OK.****Chemical testing performed to one or several of the following ASTM methods: E415, E572, E1019, E1085, E1086.****No mercury or low melting alloy contamination. No weld repair.****Material melted in Italy, manufactured in the United States.****Material conforms to listed specifications.****Quality system is compliant with ISO 9001:2000. Produced in accordance with EN 10204 3.1B.**

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes, including Federal law, Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

*Dennis Hackett*  
 \_\_\_\_\_  
 Dennis Hackett



